

Work Order ID 80422

80422

Page 1

February-21-12 9:09:51 AM

Item ID: D3639-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Doubler

Start Date: 21/02/2012 Start Qty: 8.00

8

Cust Item ID:

Required Date: 06/03/2012 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals: Process Plan: M.L.T

Date: 12/02/21 Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3639

Rev A

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3639

Dwg Rev: A

Prog Rev: A 2-

Deburr if necessary

12-2-28

(13)

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

12-2-28

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

8/2/01/29

(13)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Work Order ID 80422

80422

Page 2

February-21-12 9:09:51 AM

Item ID: D3639-1

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Doubler

Start Date: 21/02/2012 Start Qty: 8.00

8

Cust Item ID:

Required Date: 06/03/2012 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

130

Brake NC

NC BRAKE

Memo

0.00

0.00

Brake NC

Form as per Dwg D3639

SP 12/03/01

13

140

140

QC

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

Quality Control

8/26/02

13

7

150

150

HandFinish

Chemical Conversion Coat per QSI005 4.1

Memo

0.00

0.00

Hand Finishing

13

2

SP 12/03/05

W/O:		WORK ORDER CHANGES					
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Page 3

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Item ID: D3639-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Doubler

Stop *NS2*

Start Date: 21/02/2012 Start Qty: 8.00

8

Cust Item ID:

Required Date: 06/03/2012 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

160

QC3- Inspect Part Finish

0.00

160

QC

Memo

0.00

Quality Control

13 PL 12-3-5

170

Identify as per dwg & Stock Location: 244

0.00

170

Packaging

Memo

0.00

Packaging

12/3/5 (13)

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

MLJ 12/03/06

MLJ 12/03/06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

February-21-12 9:09:55 AM

Page 1
T

Work Order ID: 80422

80422

Parent Item: D3639-1

D3639-1

Parent Item Name: Doubler

Start Date: 21/02/2012

Required Date: 06/03/2012

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev:A New Issue 07-07-20 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.050		Purchased	No			100	sf	68.6000	0.239	2.012632	1.5		

M2024T3S 050

2024-T3 .050 sheet

**

B12-2-09

Location

Loc Qty

Loc Code

MAT022

68.6

117684

68.6

117682

B

W/O:		WORK ORDER CHANGES					
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DART AEROSPACE LTD		Work Order:	80422
Description: Doubler		Part Number:	D3639-1
Inspection Dwg: D3639 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.625	+0.008/-0.001	.628	2		✓ IBGZ	
Ø0.191	+0.005/-0.001	.194	2		✓	
Ø0.098	+0.004/-0.001	.098	2		✓	
0.69	+/-0.030	.689	2		✓	
1.59	+/-0.030	1.589	2		✓	
2.49	+/-0.030	2.497	2		✓	
3.39	+/-0.030	3.394	2		✓	
3.990	+/-0.010	3.987	2		✓	
4.990	+/-0.010	4.991	2		✓	
5.19	+/-0.030	5.194	2		✓	
6.99	+/-0.030	6.994	2		✓	
8.64	+/-0.030	8.646	2		✓	
0.45	+/-0.030	.451	2		✓	
0.710	+/-0.010	.713	2		✓	
2.000	+/-0.010	2.003	2		✓	
2.75	+/-0.030	2.756	2		✓	
3.55	+/-0.030	3.555	2		✓	
4.00	+/-0.030	4.007	2		✓	
2.000	+/-0.010	2.001	2		✓	
2.590	+/-0.010					

Measured by:	IB
Date:	12-2-29

Audited by:	S
Date:	12/02/19

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.10.19	New Issue	KJ/EC/DD	IB

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

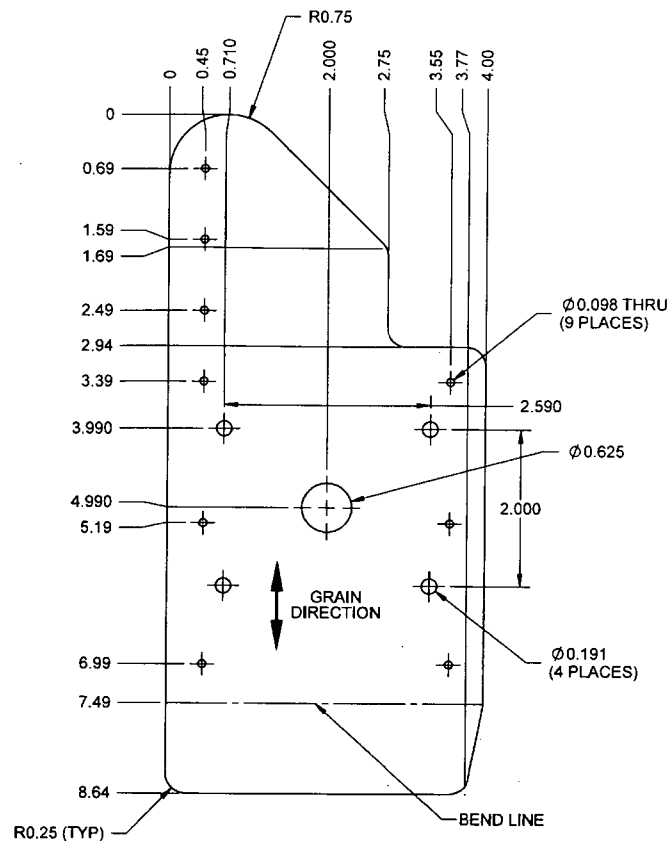
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

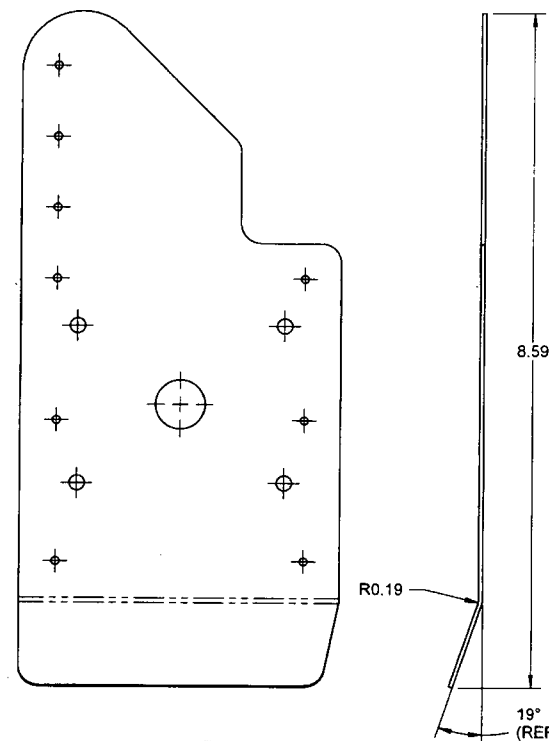
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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



D3639-1F FLAT PATTERN
(D3639-2F OPPOSITE)



D3639-1 DOUBLER
(WAS GENEVA P/N G10604-3)
D3639-2 OPPOSITE
(WAS GENEVA P/N G10604-6)



RELEASED
07-07-07

- NOTES:**
- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.050 THICK PER QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.050)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3639-1/-2" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 0.14 lbs

80422 M.C.J
12/02/21

A	NEW ISSUE; REPLACES G10604		LE	07.07.27
REV.	DESCRIPTION		BY	DATE
DESIGN	TS	DART AEROSPACE USA, INC.		
DRAWN	LE	PORT HADLOCK, WA		
CHECKED	JS	DRAWING NO.	REV. A	
MFG. APPR.	JS	D3639	SHEET 1 OF 2	
APPROVED	JS	TITLE	SCALE	
DE APPR.	JS	DOUBLER	2:3	
DATE	07.07.27	COPYRIGHT © 2007 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

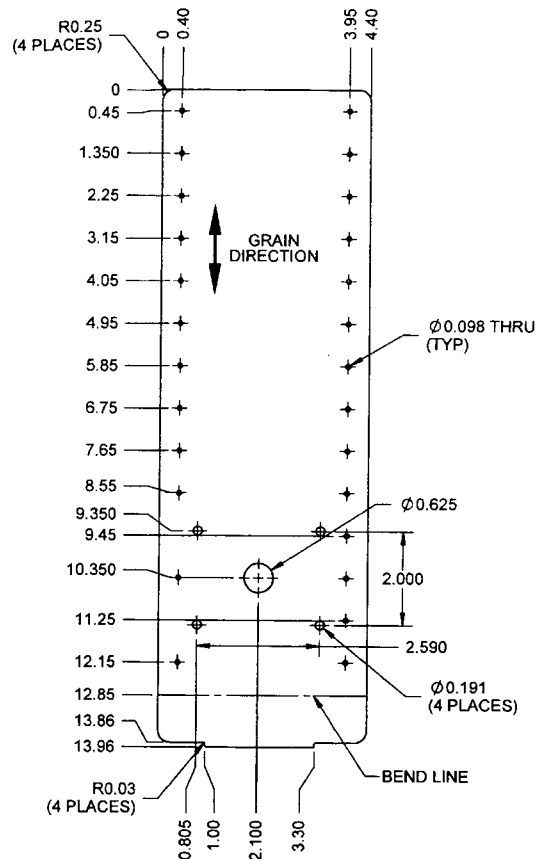
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

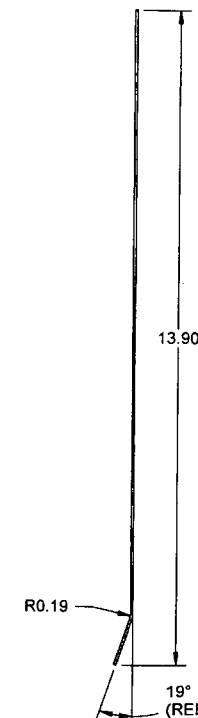
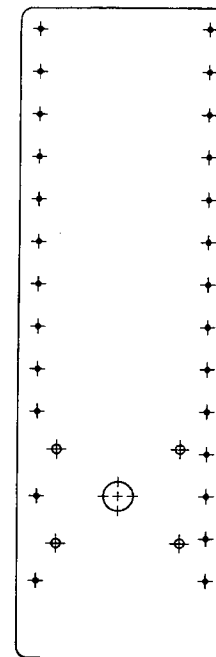
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80422



D3639-3F FLAT PATTERN
(D3639-4F OPPOSITE)



D3639-3 DOUBLER
(WAS GENEVA P/N G10604-4)
D3639-4 OPPOSITE
(WAS GENEVA P/N G10604-5)

RELEASED
07.09.07

- NOTES:
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 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3639-3/-4" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 0.3 lbs

DESIGN	TS	DART AEROSPACE USA, INC.	
DRAWN	LE	PORT HADLOCK, WA	
CHECKED	TS	DRAWING NO.	REV.
MFG. APPR.	B	D3639	SHEET 2 OF 2
APPROVED	TS	TITLE	SCALE
DE APPR.	#	DOUBLER	2
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